

Work Order ID 87316

July-13-12 11:51:58 AM

87316

Page 1

Item ID: D3901-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 7/06/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: MLJ

Date: 12/07/13

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3901

C

0.00

0.00

0.00

0.00

100

100

Cold Saw

Hyd Mech

Memo

Cut blanks at 54.75"

P0 12/08/13

4

Ø

110

110

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB090 & dwg D3901,

FOLIO REV: AA

DWG REV: 2

2-Deburr as required

B.A 12/08/13

4

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87316

87316

Page 2

July-13-12 11:51:58 AM

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 12/08/13

4

0

120

QC

Memo

0.00

Quality Control

EXTRA MATERIAL WILL BE CUT ON ASSEMBLY

130

QC8- Inspect parts - second check

0.00

SL 12-08-15

10

130

QC

Memo

0.00

Quality Control

EXTRA MATERIAL WILL BE CUT ON ASSEMBLY

140

Identify as per dwg & Stock Location: W/A

0.00

140

Packaging

Memo

0.00

Packaging

4

12-8-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-13-12 11:51:57 AM

Page 1

Work Order ID: 87316

Parent Item: D3901-1

Parent Item Name: Bar

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
verified by:JLM

IPP RevB: Now on cnc JFS 12/02/13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	566.4540	4.513	19.002105			

30 12/08/13

Location	Loc Qty	Loc Code
MAT050	566.454	
121216	142.08	
121547	63.904	
122008	360.47	

4.52 19.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	87314
Description: Bar		Part Number:	D3901-1
Inspection Dwg: D3901	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

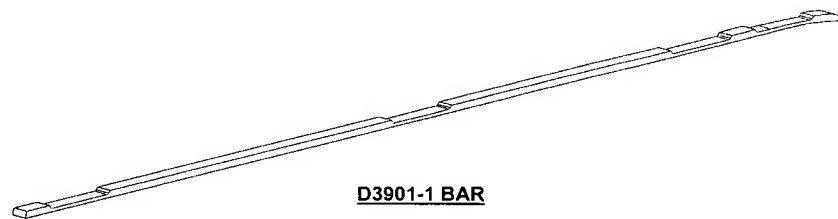
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+0.006/-0.001	N/A				
0.28	+/-0.030	0.250	✓		Vern	GA-01
1.50	+/-0.030	N/A				
4.00	+/-0.030	3.990	✓		Vern	GA-01
24.00	+/-0.030	24.00	✓		Tape	GA-12
42.45	+/-0.030	42.45	✓		"	"
48.00	+/-0.030	48.00	✓		"	"
54.2	+/-0.100	54.160	✓		"	"
0.130	+/-0.010	0.128	✓		Vern	GA-01

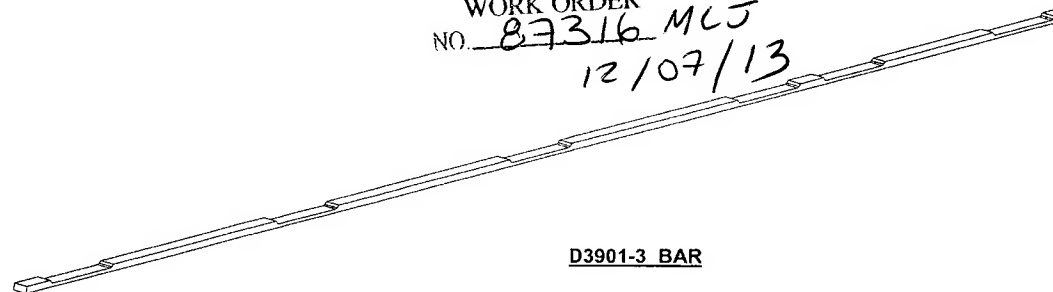
Measured by: B.A	Audited by: SL	Prototype Approval: N/A
Date: 12/08/13	Date: 12-08-15	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	

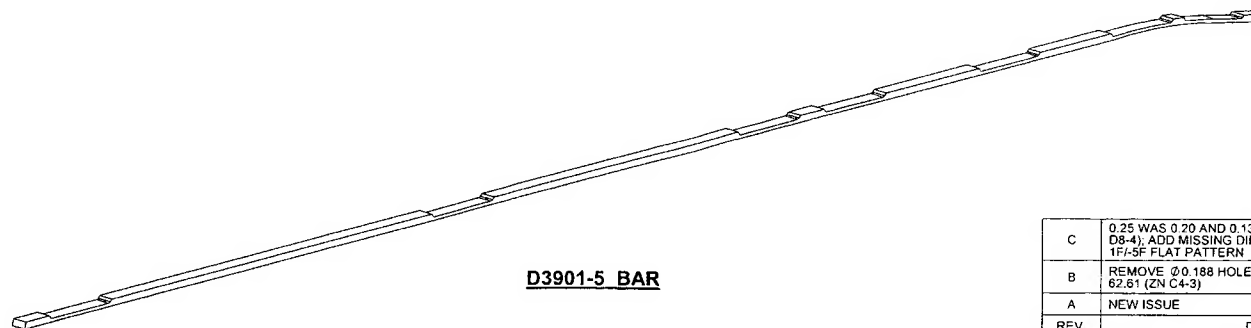
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87316 MLJ
12/07/13



D3901-1 BAR



D3901-3 BAR

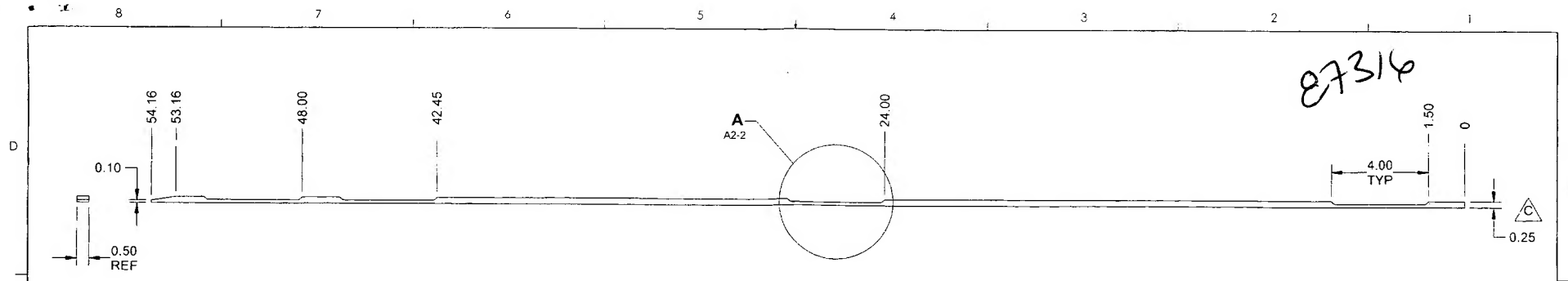


D3901-5 BAR

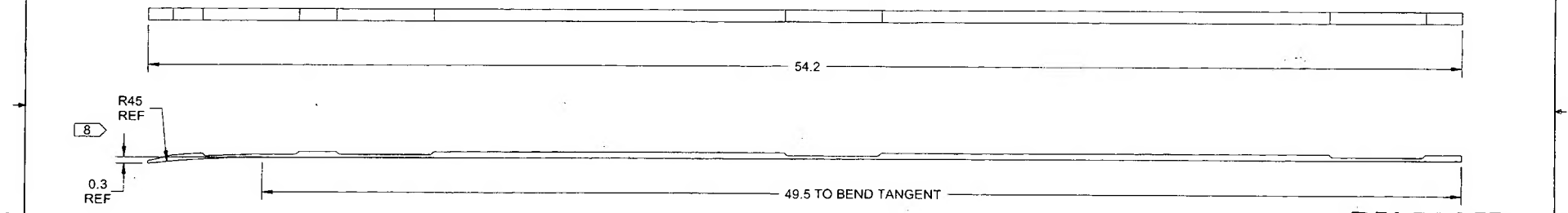
RELEASED
2012-06-27
[Signature]

C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901, 1F-5F FLAT PATTERN	RF	12.01.24
B	REMOVE Ø0.188 HOLES FROM D3901-1/-3/-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3901	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
DATE	12.01.24	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

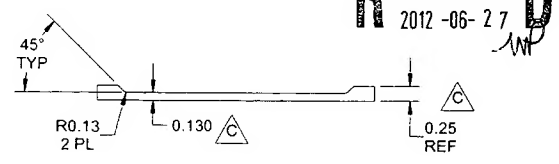
87314



D3901-1F BAR FLAT PATTERN



**D3901-1 BAR
(MAKE FROM D3901-1F)**



DETAIL A
TYP. SCALE 2X

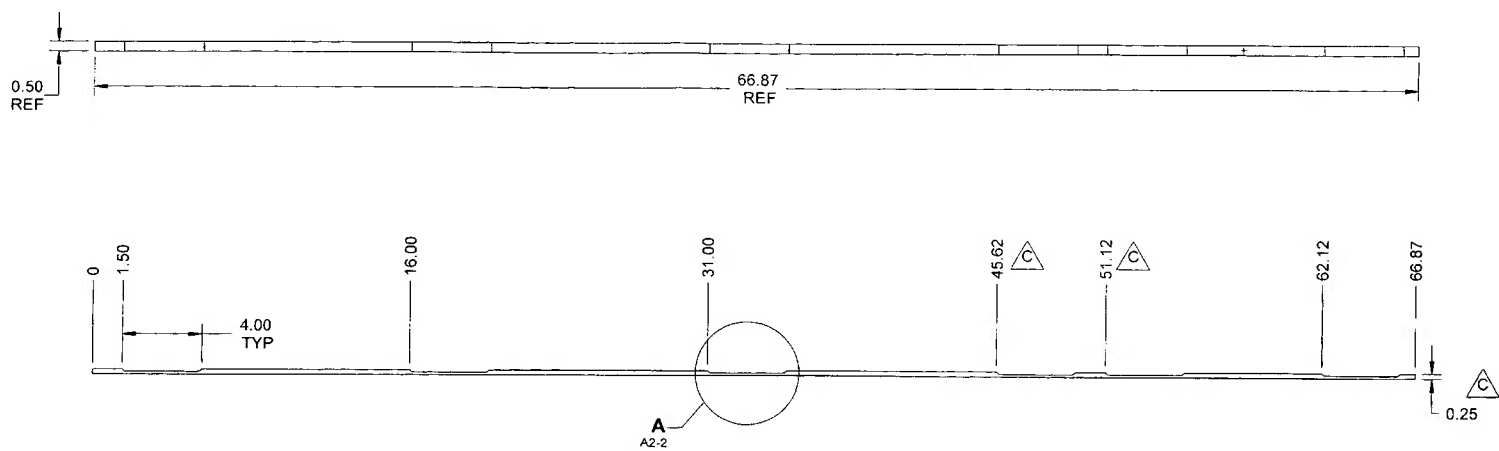
RELEASED
2012-06-27

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.68 lbs
- 8) FORM TO FIT WEARPLATE

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3901	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
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27316



D3901-3 BAR

RELEASED
2012-06-27

NOTES:

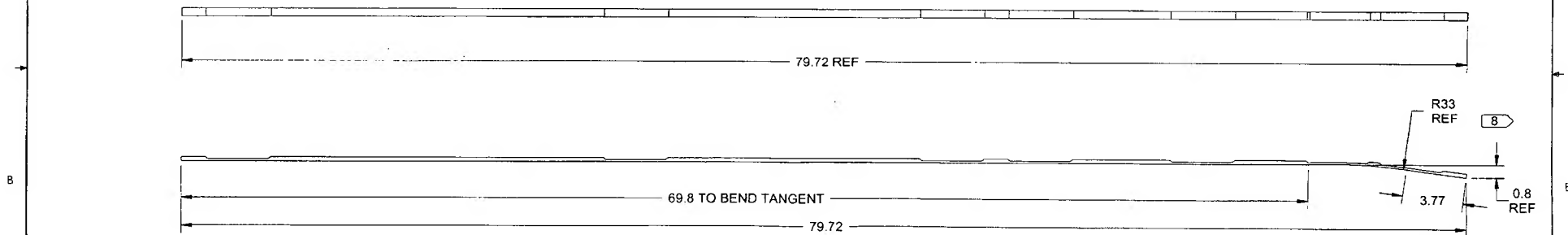
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.01 lbs

DESIGN		RF		DART AEROSPACE USA, INC.	
DRAWN		RF		KENT, WA	
CHECKED		<i>[Signature]</i>		DRAWING NO. D3901	
MFG. APPR.		<i>[Signature]</i>		REV. C SHEET 3 OF 4	
APPROVED		<i>[Signature]</i>		TITLE BAR	
DE APPR.		<i>[Signature]</i>		SCALE NTS	
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87318



D3901-5F BAR FLAT PATTERN



**D3901-5 BAR
(MAKE FROM D3901-5F)**

RELEASED
2012-06-27

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.40 lbs
- 8) FORM TO FIT WEARPLATE

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3901	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
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